

CI cond  
at least 10% by weight, based upon the weight of the blend, of a second polymer having a melting point between 85 to 110°C comprising a copolymer of ethylene and at least one  $\alpha$ -olefin; and

at least 10% by weight, based upon the weight of the blend, of a third polymer having a melting point between 115 to 130°C consisting of a thermoplastic polymer selected from the group LDPE, HDPE, LLDPE, propylene copolymers, and a copolymer having a density of 0.900 to 0.915 g/cm<sup>3</sup> consisting of ethylene and at least one  $\alpha$ -olefin.

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CK  
12. (Twice Amended) A flexible film having at least one layer comprising a blend of at least three polymers comprising:

at least 10% by weight, based upon the weight of the blend, of a first polymer having a melting point between 55 to 75°C comprising a copolymer selected from the group of a copolymer of ethylene and at least one  $\alpha$ -olefin having a melt index of up to 1.0 dg/min according to ASTM D-1238 and 190°C, and a copolymer of ethylene and at least one C<sub>6</sub> to C<sub>10</sub>  $\alpha$ -olefin;

at least 10% by weight, based upon the weight of the blend, of a second polymer having a melting point between 85 to 110°C comprising a copolymer of ethylene and at least one  $\alpha$ -olefin; and

at least 10% by weight, based upon the weight of the blend, of a third polymer having a melting point between 115 to 130°C consisting of a polymer selected from the group LDPE, HDPE, LLDPE, propylene copolymers, and a copolymer having a density of 0.900 to 0.915 g/cm<sup>3</sup> consisting of ethylene and at least one  $\alpha$ -olefin.

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C3  
32. (Twice Amended) A biaxially stretched, heat shrinkable film comprising at least three layers, wherein said first layer is a heat sealable surface layer and consists essentially of a blend of at least four polymers comprising:

at least 10% by weight, based upon the weight of the blend, of a first polymer having a melting point between 55 to 75°C comprising a copolymer of ethylene and at least one  $\alpha$ -olefin;

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at least 10% by weight, based upon the weight of the blend, of a second polymer having a melting point between 85 to 110°C comprising a copolymer of ethylene and at least one  $\alpha$ -olefin; and

at least 10% by weight, based upon the weight of the blend, of a third polymer having a melting point between 115 to 130°C comprising a polymer selected from the group LDPE, HDPE, LLDPE and, a copolymer having a density of 0.900 to 0.915 g/cm<sup>3</sup> consisting of ethylene and at least one C<sub>4</sub>-C<sub>8</sub>  $\alpha$ -olefin; and a fourth polymer having a melting point between 80 to 105°C; a third layer comprising at least 50 percent by weight of copolymer of ethylene with at least one alpha-olefin or at least one vinyl ester or blends thereof, and a second layer between said first and third layers; said second layer comprising a vinylidene chloride copolymer, a nylon or a copolymer of ethylene with a vinyl alcohol.

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CH  
34. (Twice Amended) A thermoplastic film of at least two layers comprising, a first layer comprising a first polymer (A) having a melting point between 115 to 130°C selected from the group LDPE, HDPE, LLDPE, propylene copolymers and a copolymer having a density of 0.900 to 0.915 g/cm<sup>3</sup> consisting of ethylene and at least one C<sub>4</sub>-C<sub>8</sub>  $\alpha$ -olefin; and a second polymer (B) having a melting point between 80 to 105°C, and a second layer in direct contact with said first layer without any interposed thermoplastic film layer, said second layer comprising a third polymer (C) having a melting point between 55 to 75°C comprising a copolymer selected from the group of a copolymer of ethylene and at least one  $\alpha$ -olefin having a melt index of up to 1.0 dg/min according to ASTM D-1238 at 190°C, and a copolymer of ethylene and at least one C<sub>6</sub> to C<sub>10</sub>  $\alpha$ -olefin.

35. (Twice Amended) A biaxially stretched, heat shrinkable film comprising at least five layers wherein said first layer comprises a blend of at least three polymers comprising:

a first polymer having a melting point between 55 to 75°C, comprising a copolymer of ethylene and at least one  $\alpha$ -olefin;

a second polymer having a melting point between 85 to 110°C, comprising a copolymer of ethylene and at least one  $\alpha$ -olefin;

C4  
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a third polymer having a melting point between 115 to 130°C, consisting of a thermoplastic polymer selected from the group LDPE, HDPE, LLDPE, propylene copolymers and a copolymer having a density of 0.900 to 0.915 g/cm<sup>3</sup> consisting of ethylene and at least one C<sub>4</sub>-C<sub>8</sub> α-olefin; and optionally a fourth polymer having a melting point between 80 to 105°C; a second layer comprising an ethylene copolymer; a fourth layer comprising an ethylene copolymer; a third layer between said second and fourth layers, said third layer comprising a vinylidene chloride copolymer, a nylon or a copolymer of ethylene with a vinyl alcohol; and a fifth layer comprising at least 50 percent by weight of copolymer of ethylene with at least one alphas-olefin or at least one vinyl ester or blends thereof.

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C5

37. (Twice Amended) A process for making a biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising a first polymer having a melting point between 55 to 75°C, comprising a copolymer of ethylene and at least one α-olefin; a second polymer having a melting point between 85 to 110°C, comprising a copolymer of ethylene and at least one α-olefin; a third polymer having a melting point between 115 to 130°C, consisting of a thermoplastic polymer selected from the group LDPE, HDPE, LLDPE, propylene copolymers and a copolymer having a density of 0.900 to 0.915 g/cm<sup>3</sup> consisting of ethylene and at least one C<sub>4</sub>-C<sub>8</sub> α-olefin; and optionally a fourth polymer having a melting point between 80 to 105°C;

cooling said primary tube;

reheating said cooled tube to a draw point temperature between about 65 to 88°C;

biaxially stretching said tube to a circumference of at least 2½ times the circumference of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film.

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Please cancel Claim 11 without prejudice.